



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PC250-420
Job Sheet 173457



Part No: PC250-420

Job Qty: 5 ea

Part Name: Inner Keeper



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/2/18

Job Tracking No:

Due Date: 3/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C250-400 Rev A IPP Rev A 18.03.01 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	5 Ea		3/15/18	0.00	0.00	Start Up Waterjet2		De 18/03/18
110	Waterjet	5 pcs		3/15/18	0.00	0.50	Waterjet 2 OMAX		De 18/03/18
120	QC	5 pcs		3/15/18	0.00	0.00	QC2 Waterjet-2		De 18/03/18
130	QC	5 pcs		3/15/18	0.00	0.00	QC8-6		38
140	Small Fab	5 pcs		3/16/18	0.00	0.50	Small Fab-3		9-89
150	QC	5 pcs		3/16/18	0.00	0.00	QC5		
160	Packaging	5 pcs		3/16/18	0.00	0.00	Packaging3-1		
170	QC21-SA	5 Ea		3/16/18	0.00	0.00	QC21		

Part Op 100 -

Descriptions: 110 - 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary

140 - 1-Form as per DWG. 2-Remove tabs

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S188	304 Sheet 0.188	.4800 sf (.096 ea)	100-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	M304S188	0	42	0

Part Specifications

Specifications could not be found.

Plex 3/2/18 8:38 AM Dart.lajeunesse.marie

Lo
Scrap.

Done
3/2/18



Container No: S047886

Part: PC250-420

Job No: 173457

Serial No/Batch: S047886

Revision: A

Inspector:

Dart Aerospace Ltd.
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CANADA
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Date: 03/05/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

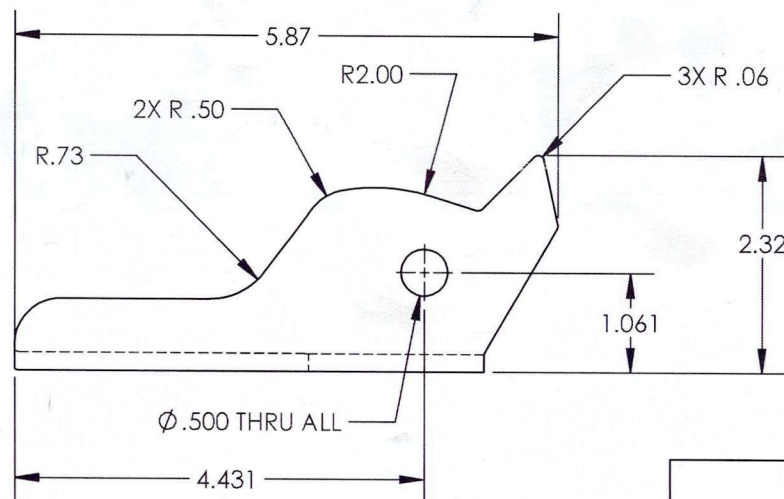
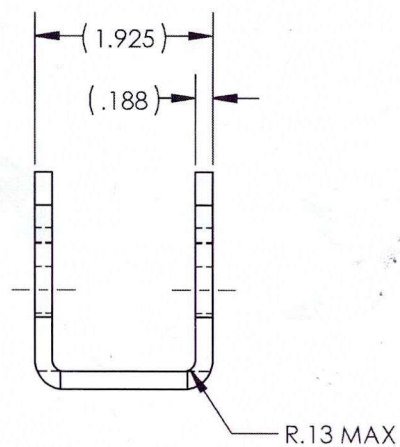
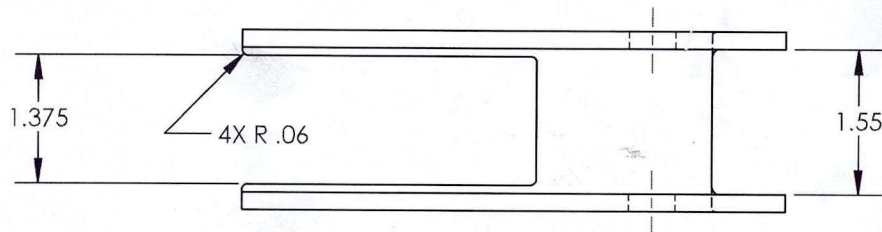
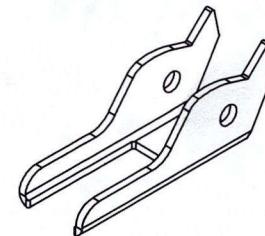
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
A	14-0129	PC250-420 ADDED MISSING DIMS R.73, 2X R.50, R2.00, 3X R.06.			8/14/2014	DPD	RW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173457MCS
180302

PC250-420

INNER KEEPER

DART AEROSPACE	
TITLE KEEPER ASSEMBLY	
DWG NO. PC250-400	REV A
MAT'L 1030	DRAWN BY: APICAL
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005	FRACTIONS ± 1/8
.XX ± .01	ANGLES ± 5°
.X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 7/8/2004
SHEET 2 OF 3	